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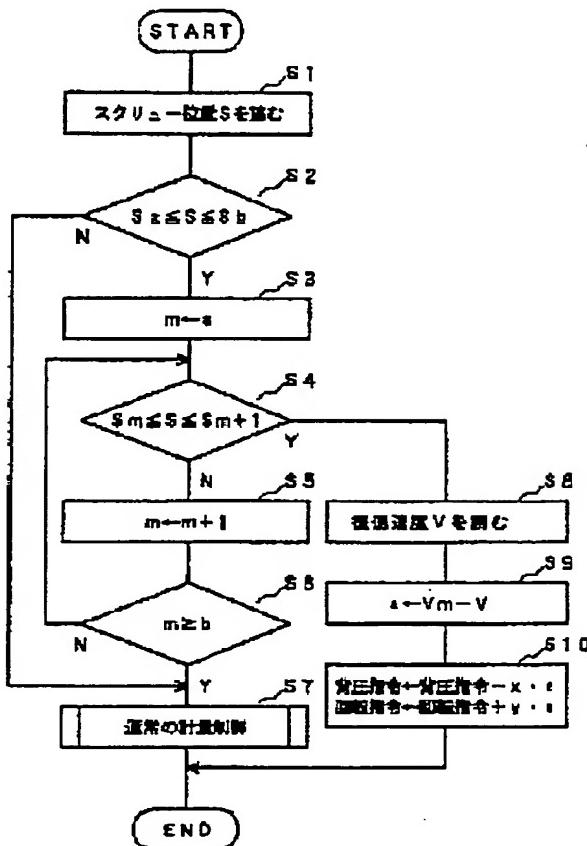
APPLICATION DATE : 19-01-94
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APPLICANT : FANUC LTD;

INVENTOR : HASE MOTOHIRO;

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TITLE : SCREW ROTATION CORRECTING APPARATUS



ABSTRACT : PROBLEM TO BE SOLVED: To provide a screw rotation correcting apparatus for an injection molding machine for holding an internal pressure of a reservoir at a predetermined value according to a screw position.

SOLUTION: Screw retracting speeds V are sequentially detected in a metering step, and a speed deviation ϵ of the retracting speed V from a screw retracting speed V_m of a reference metering step at the time of molding a good product is obtained (S9). This deviation is regarded as being generated according to a change of a force required for conveying, plasticizing or the like of a resin in an injection cylinder. Then, a screw rotating speed is corrected in a direction for eliminating its deviation ϵ according to a directional property of the deviation ϵ (S10). A force required for conveying or plasticizing the resin in the cylinder is changed by the correction of the speed of the screw, and the resin in the reservoir at an end of the cylinder is held at substantially the same pressure as that in the reference step. Since properties of the molten resin is stabilized according to stability in the internal pressure of the reservoir, an injection molding work having little molding fault can be performed.

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